

REPRINT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872882-5
Job Sheet 183464



Part No: RB6872882-5

Job Qty: 6 ea

Part Name: Ring



Part Weight: 0 lbs

Job Created: 9/18/18

Due Date: 10/1/18

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Logan David

Description:

Note: DWG RB6872882 Rev. 5 IPP Rev. A 18.09.17 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		10/1/18	0.00	0.00	Start Up Machining-4		PL 16-10-18
120	Lathe Conv	6 pcs		10/1/18	0.00	1.50	Lathe Conv-2		PL 16-10-18
130	QC	6 pcs		10/1/18	0.00	0.00	QC2 Machining-5		PL 16-10-18
140	QC	6 pcs		10/1/18	0.00	0.00	QC8 Machining-5		PL 18/10/18
150	Outsource	6 pcs		10/1/18	0.00	0.00	Outsource12		OCT 26 2018
160	Packaging	6 pcs		10/1/18	0.00	0.00	Packaging2		OCT 26 2018
170	QC	6 pcs		10/1/18	0.00	0.00	QC6		38
180	Packaging	6 pcs		10/1/18	0.00	0.00	Packaging3-2		9-89
190	QC21-SA	6 Ea		10/1/18	0.00	0.00	QC21		OCT 30 2018

Part Op 120 - 1-Machine as per DWG. 2-Deburr

Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO 41373 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

OCT 18 2018

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R3.500	M1018R3.500	.3750 ft (.0625 ea)	90-Start up Operation	S047937

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R3.500	0	4	0

Part Specifications

Specifications could not be found.

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OCT 3 1918
OCT 3 1918

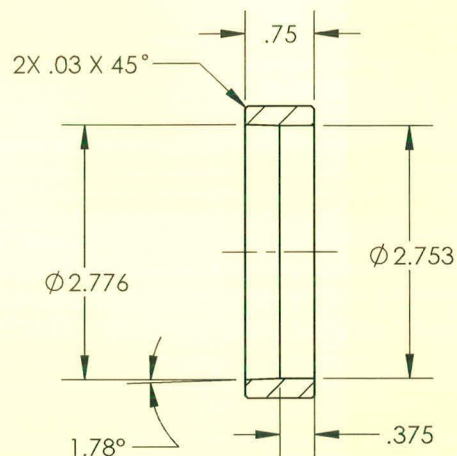
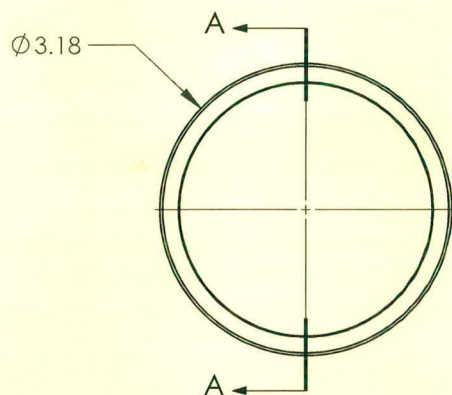
OCT 3 1918

INSPECTION SHEET

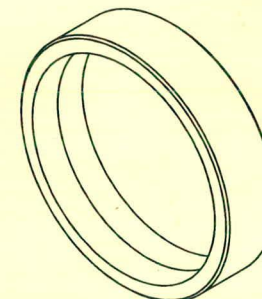
Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED -5 FROM INCLUDE ANGLE .750 TP PER FT. 0°53'37" TO .89°	-	-	-
4	15-0046	ANGLE WAS 0.89° NOW 1.78°. ADDED DIMENTION 0.375.	6/29/2015	SM	JAG
5	17-0110	-5 CH'D DIM WAS 2.765 IS Ø2.776. CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



SECTION A-A



(-5)
RING

DART AEROSPACE	
TITLE PULLER, TURBINE FRONT BEARING	
DWG NO. RB6872882-5	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 05/09/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/24/2017	USED ON MODEL
APPROVED: JAG 06/02/2017	ALLISON 250 SERIES
SCALE 1:2	DATE 5/18/2007 SHEET 5 OF 13



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S118916



Part: RB6872882-5

Job No: 183464

Serial No/Batch: S118916

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 10/16/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041373**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041373
PO Date: 10/18/18
Due Date: 10/24/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183464	RB6872882-5	Ring -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/24/18	7 pcs	0 pcs	7 pcs	\$5.1428571/pcs	\$36.00
Grand Total:											\$36.00

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C2



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PURCHASE ORDER PO041373

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

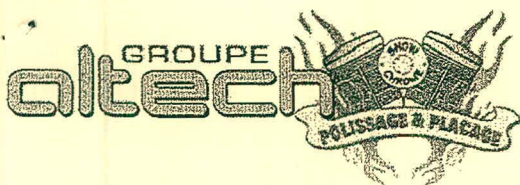
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/26/18 8:22 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(013655-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

013655-1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
24-Oct-2018		Aman		041373				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6872882-5 Rev.	RB6872882-5 BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MILL-C23411 A OR MIL-PRF- 81309 AND WIPE OFF ECXESS	BLACK-OXIDE CH	7	7	0	0	0
2	RBE2-10-1-01 Rev.	RBE2-10-1-01 01 -BLACK OXIDE MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4	BLACK-OXIDE CH	8	8	0	0	0
3	RBT103331-101 Rev.	RBT103331-101 BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MILL-C23411 A OR MIL-PRF- 81309 AND WIPE OFF ECXESS	BLACK-OXIDE CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

